



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3110

Job Sheet 185759



Part No: 646.3110

Job Qty: 10 ea

Part Name: Channel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/23/18

Type: Stock

Description:

Note: DWG 646.3100 REV N/C IPP REV:A NEW ISSUE 12-10-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/23/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	10 pcs		11/23/18	0.00	0.55	Bandsaw1		
110	CNC Vertical Machining	10 pcs		11/23/18	0.43	11.11	HAAS1-1		
120	QC	10 pcs		11/23/18	0.00	0.00	QC2 Machining-1		
130	QC	10 pcs		11/23/18	0.00	0.00	QC8 Machining-1		
140	Outsource	10 pcs		11/23/18			ATG001-VC	8	
150	Packaging	10 pcs		11/23/18	0.00	0.00	Packaging2		
155	QC	10 pcs		11/23/18	0.00	0.00	QC5		
180	Packaging	10 pcs		11/23/18	0.00	0.00	Packaging3-1		
190	QC21-SA	10 Ea		11/23/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 15.00"

Descriptions: 110 - 1-Machine per folio FB145

140 - Issue P/O to ATG : 20042031-1- Hard Anodize Black and Prime as per Dwg 646.3100

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.500X1.500	7075-T6S Sheet 1.5" Thick Plate X 1.5" Wide	12.5000 ft (1.25 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.500X1.500	13	4	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Channel	14.600inches ± 0.010	14.610 14.590		
2	Channel	13.130inches ± 0.010	13.140 13.120		
3	Channel	0.090inches ± 0.010	0.100 0.080		
4	Channel	0.470inches ± 0.010	0.480		

DOA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Thermoforming Large Fab ☐ Cross tube Small Fab ☐ Finishing Composite ☐ Water Jet Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐	
Date: _____		Step #: _____		QTY Effective: _____	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	
				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	
				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	
Positioning Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____		QC / QA Coordinator Approval	

			0.460	
5	Channel	0.750inches $\pm$ 0.010	0.760 0.740	
6	Channel	83.000Degrees $\pm$ 0.500	83.500 82.500	Angle
7	Channel	0.880inches $\pm$ 0.010	0.890 0.870	
8	Channel	0.645inches $\pm$ 0.005	0.650 0.640	
9	Channel	0.110inches $\pm$ 0.010	0.120 0.100	
10	Channel	0.120inches $\pm$ 0.010	0.130 0.110	
11	Channel	0.209inches $\pm$ 0.005 - 0.001	0.214 0.208	Diameter
12	Channel	0.409inches $\pm$ 0.005	0.414 0.404	
13	Channel	0.420inches $\pm$ 0.002	0.422 0.418	
14	Channel	2.188inches $\pm$ 0.002	2.190 2.186	
15	Channel	2.188inches $\pm$ 0.002	2.190 2.186	
16	Channel	2.188inches $\pm$ 0.002	2.190 2.186	
17	Channel	2.187inches $\pm$ 0.002	2.189 2.185	
18	Channel	0.785inches $\pm$ 0.002	0.787 0.783	
19	Channel	2.395inches $\pm$ 0.002	2.397 2.393	
20	Channel	0.669inches $\pm$ 0.002	0.671 0.667	
21	Channel	0.372inches $\pm$ 0.002	0.374 0.370	
22	Channel	0.334inches $\pm$ 0.002	0.336 0.332	
23	Channel	0.175inches $\pm$ 0.002	0.177 0.173	
24	Channel	0.130inches $\pm$ 0.002	0.132 0.128	

Plex 11/1/18 1:53 PM Dart.laieunesse.marie

DART
 AEROSPACE
 1270 Aberdeen Street
 Haverhill, MA 01830
 TEL: 978 332-5200
 Email: sales@dartaero.com
 www.dartaerospace.com
 URT Aerospace Ltd.
 1270 Aberdeen Street
 Haverhill, MA 01830
 TEL: 978 332-5200
 Email: sales@dartaero.com
 www.dartaerospace.com
 Part: 646.3110
 Job No: 185759
 Serial No/Batch: S136495
 Revision:
 Inspector:
 Exp Date:
 Instructions:
 Date: 12/10/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering			
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐			
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐			
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐			
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date: _____		Step #: _____		QTY Effective: _____				MRB (QS1042) Approval			
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment		No Re-verification		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong	
Design		Operator		Bending		Set-up		Folio/Program		Outside Dimensions	
Doc/Data		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance	
Equip/Tooling		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect	
Handling/Pre		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing	
Material		Use for Testing		Cuffs		Contamination		Out of Sequence		Part Moved	
Internal Transport		Poor Information		Crushing		Countersink		Off-set		Drawing	
Tribal Knowledge		Rushing		Heat Treat		Cut Too Short		Mislabeled		Finish	
LOA		Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread	
Substation		Process Improvement		Marks/Chatter				Misaligned/off center		Turning Sequence	
Past Expiry Date		Manufacturing Process									
Misidentified		Past Due									
				OTHER: _____							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042031**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO042031
PO Date: 12/12/18
Due Date: 12/21/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Attention: Lalonde, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187615	647.7820	Cross Bracket Aft Outsource process- Anodize per QSI017 4.1.10.1 Issue P/O TO ATG: _____ Anodize & prime as per Dwg. 647.7800	Firmed	-	12/21/18	4 pcs	0 pcs	4 pcs	\$24.56/pcs	\$98.24
2	185759	646.3110	Channel Issue P/O to ATG : _____ 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	-	12/21/18	10 pcs	0 pcs	10 pcs	\$24.56/pcs	\$245.60
3	185451	RBE105- 31781W2- 3	Base -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/21/18	8 pcs	0 pcs	8 pcs	\$11.35/pcs	\$90.80

Plex 12/14/18 12:31 PM dart.tsimiklis.chrisoula



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042031**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$434.64

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/14/18 12:31 PM dart.tsimiklis.chrisoula

